

Date: Tuesday, 30/09/2008 8:54:21 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP LEG
 Job Number : 42344C
 Estimate Number : 10382
 P.O. Number :
 This Issue : 30/09/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SMALL /MED FAB
 Previous Run : 41445C
 Part Number : D30655
 Drawing Number : D3065 REV. B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 15/10/2008 Qty: ~~200~~ 100 Um: Each
 Written By :
 Checked & Approved By : JLD 08.9.30
 Comment : Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF
 Est Rev:D Now on Water Jet 06-04-11 JLM
 Est Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 1.1338 sf(s)/Unit Total : 113.3790 sf(s)
 Material: 6061-T6 0.080" thick
 (M6061T6S.080)

Batch: 108433X

79.5

HB 8-10-29

109184X 37 = 42

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D

Dwg Rev: BProg Rev: B

HB 8-10-29

2-Deburr if necessary

HB 8-10-29

(107)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-10-29

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 08/10/30

recenter

(107)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JLD

08-10-31

(107)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 30/09/2008 8:54:21 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 42344C

Part Number: D30655

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(107)

Comment: INSPECT CHEMICAL CONVERSION COAT

FY 08/10/31

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Syluie

JS 08/10/31 (107)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	5						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 423440
Description: Step Leg		Part Number: D3065-5
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	16.458	✓			
15.750	+/-0.005	15.750	✓			
2.250	+/-0.005	2.250	✓			
3.460	+/-0.005	3.462	✓			
0.865	+/-0.005	.869	✓			
6.020	+/-0.005	6.022	✓			
1.205	+/-0.005	1.205	✓			
3.484	+/-0.005	3.487	✓			
0.871	+/-0.005	.874	✓			
8.325	+/-0.010	8.325	✓			
0.551	+/-0.010	.556	✓			
0.213	+0.005/-0.000	.218	✓			
Ø0.128	+0.005/-0.000	.131	✓			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 8-10-29	Date: 08/10/30	Date:	N/A

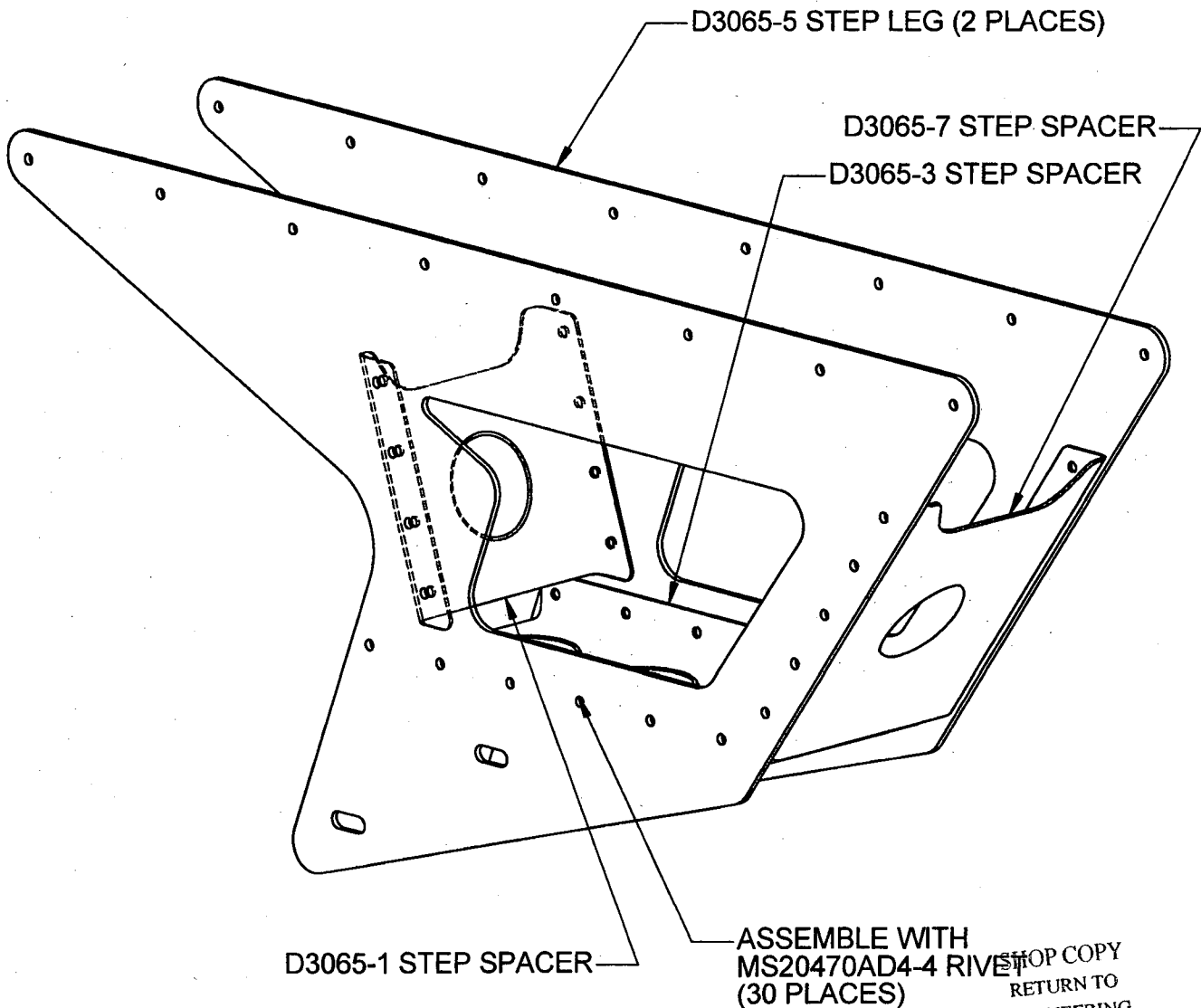
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.06.15	Added Ø0.128 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*

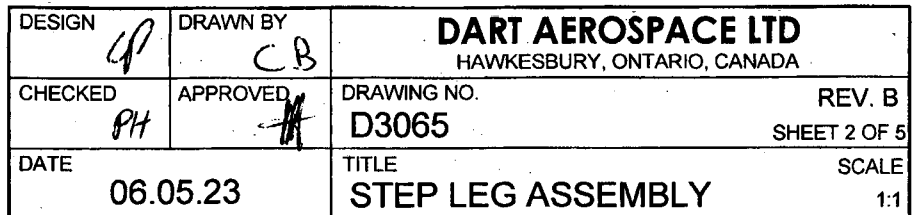


D3065-041 STEP LEG ASSEMBLY

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de de-20 $\frac{1}{10}$

D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M20)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) BREAK ALL SHARP EDGES 0.005 TO 0.010
4) PART IS SYMMETRIC ABOUT CENTERLINE
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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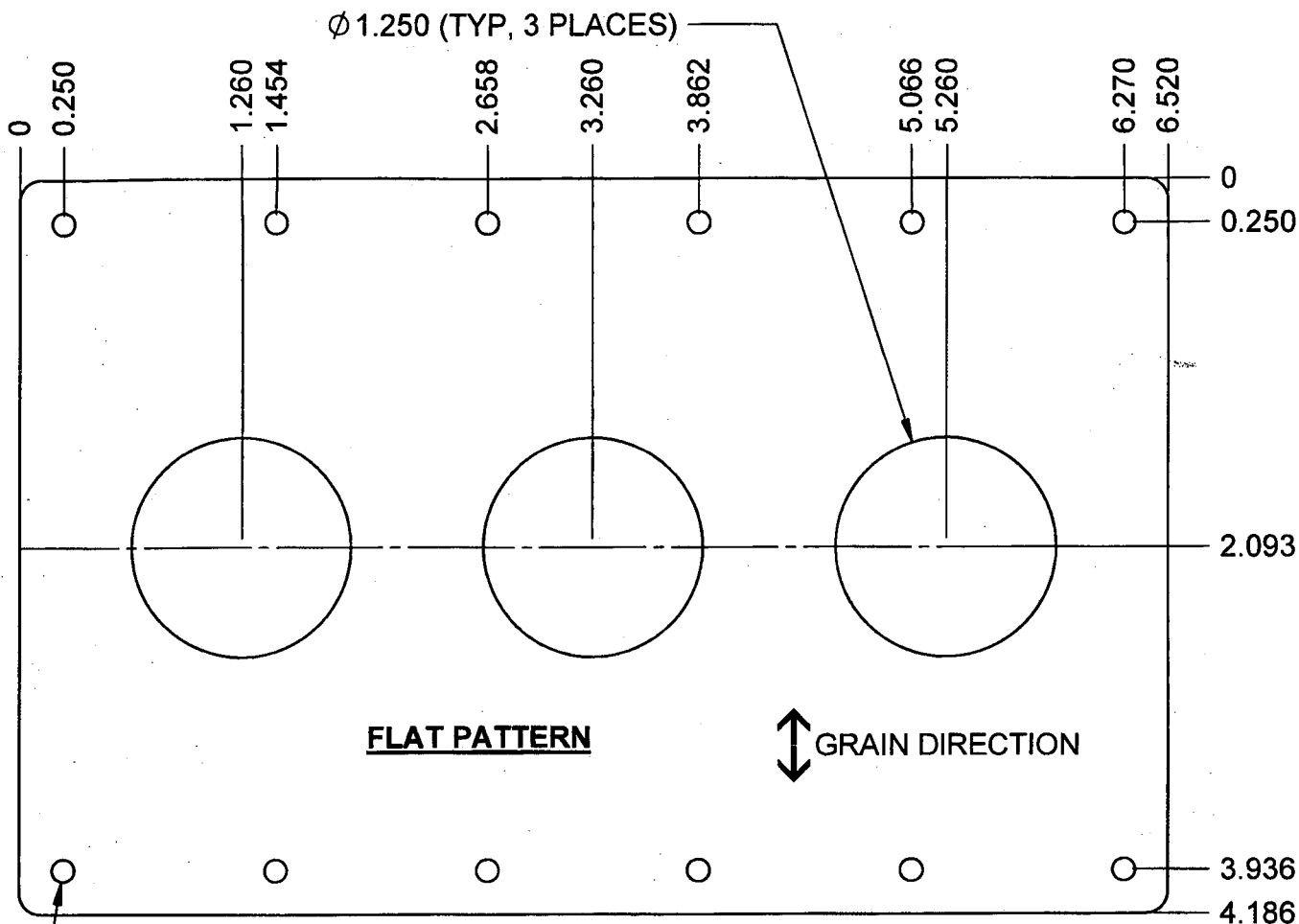
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

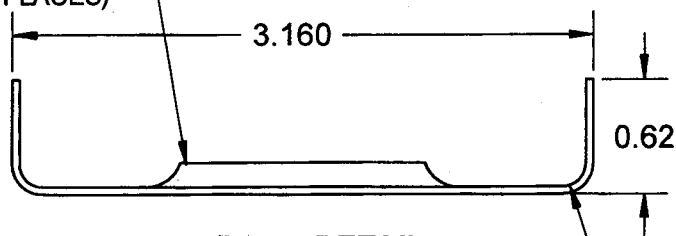


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06.06.20 *[Signature]*



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

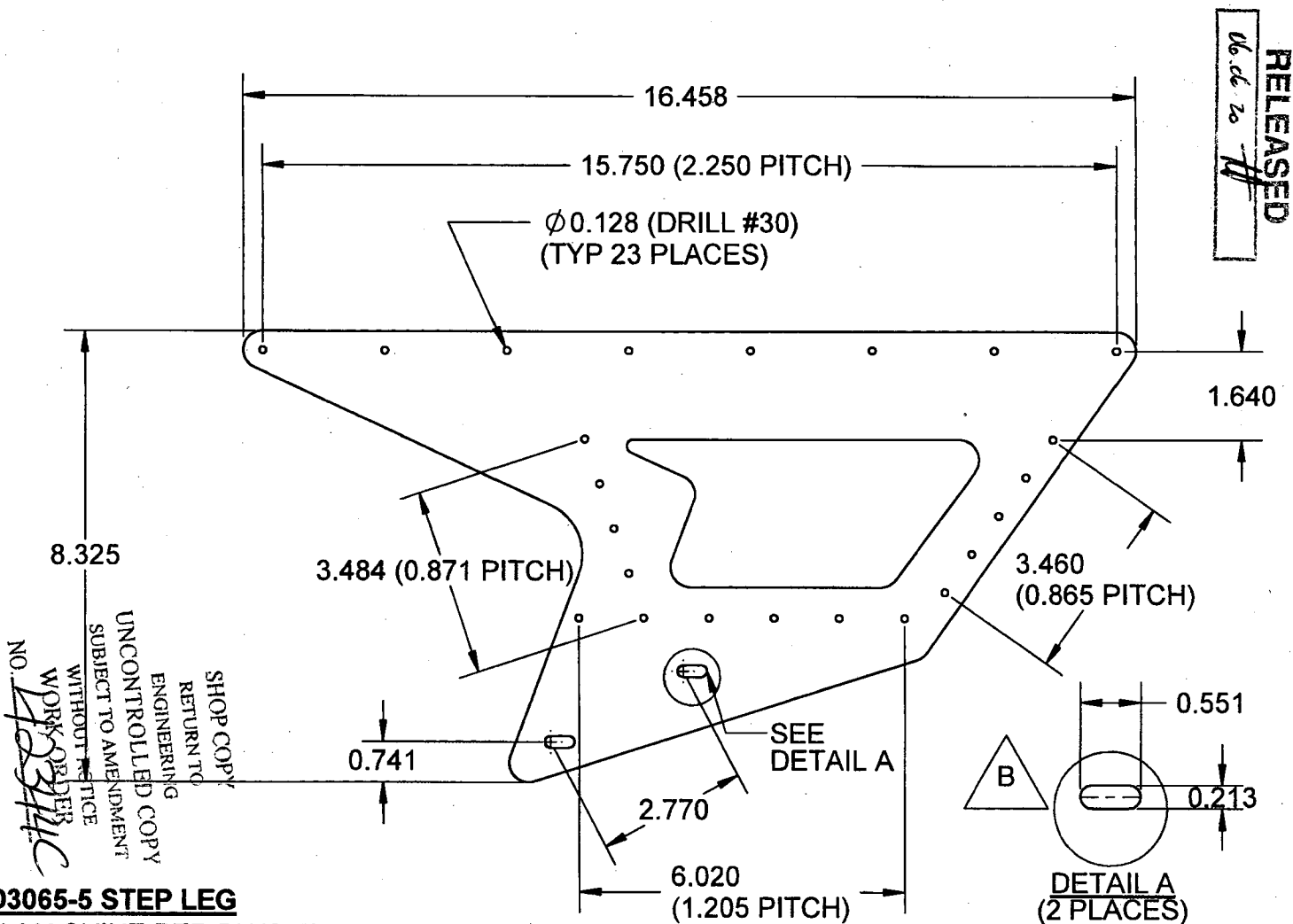
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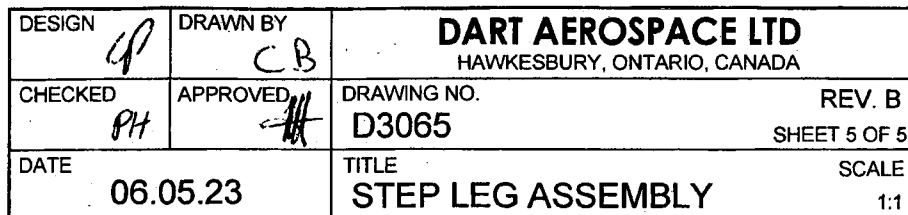
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
04		
DATE	TITLE	REV. B
06.05.23	STEP LEG ASSEMBLY	SHEET 4 OF 5
		SCALE 1:3

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES


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FLAT PATTERN

RELEASED

de de re 

0.62

3.160

R0.125 (TYP)

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) PART IS SYMMETRIC ABOUT CENTERLINE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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